

Work Order ID 57450

April 7, 2010 9:54:07 AM



Page 1

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 07/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3172

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Qty 4 D3166-1 as per Dwg D3172 □ 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 □ 3-Drill holes in D3172-3 as per Dwg D3172 □ 4-Deburr & Remove all markings from material □ 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Deburr as r

By 10/09/03 (K)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 10.09.04

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/10/08/04

(H)

W/O:		WORK ORDER CHANGES					
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Run Start



Stop



Sequence ID/
Work Center ID

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Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

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Qty

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Qty

Reject
Number

Insp.
Stamp



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 114841

Memo

0.00

IST COAT: 3:00
START TIME: 3:00
OVEN TEMPERATURE: 1600
FINISH TIME: 3:30

***** 2nd coat if necessary*****

2ND COAT:
START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

1 BR 10-8-4,

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

EF 5/10/08/05 @

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Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev. Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location

G.A

0.00

Memo

w/o 57449

0.00

Packaging

EP 12/08/05 @

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/05 AJ

MF
10-8-05

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Picklist Print

April 7, 2010 9:54:12 AM

Page 1

Work Order ID: 57450

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly


Comments: IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117		Manufactured	No			100	Each	39.0000	2.0000			
												
✓ Clevis												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	39	
52498	9	
55729	30	

D2232-3

Manufactured No

100 Each

7.0000 2.0000



✓ Basket Hinge

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	7	
54863	7	

D2327-3

Manufactured No

100 Each

31.0000 2.0000



✓ Spacer Bushing

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	31	
55917	11	
57186	20	

SY 10/07/28

②
B60325 ② SY 10/07/28

B59980 ② SY 10/07/27

W/O:		WORK ORDER CHANGES						
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Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	15.0000	2.0000			

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

15

46086

2

51745

2

55918

11

Manufactured No

100

Each

13.0000

4.0000

10/07/27
B60198 2x

Warehouse

Location

Main Warehouse

WA

Loc Qty

13

55824

1

56395

12

Manufactured No

100

Each

12.0000

8.0000

10/07/27
B60269 ④

Warehouse

Location

Main Warehouse

WA

Loc Qty

12

41632

12

Loc Code

10/07/27
B59636 ④

④

April 7, 2010 9:54:12 AM

Shop Packet Print

Page 2

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IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure
M304EX0.75-16F		Purchased	No			100	sf



Expanded Metal Flat SS

Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
656.3474	48.0000			



SAD 10-08-04

Warehouse Location	Loc Qty
Main Warehouse	
MAT	656.3474
111956	28
112949	12
113497	28
113555	303.45
113904	43.2132
114212	241.6842

Loc Code
m 115171 → 42.00
m 115067 → 6.00

M304TS0.750W.065

Purchased

No

100

f



304 SQ Tube .75x.75x.065W

Warehouse Location	Loc Qty
Main Warehouse	
WA	530.2458
111148	58
113956	23.5
114137	448.7458

530.2458 53.6842



10/07/07
M115274 - 53.6842
EVD BAR SCRAP 36' inch

April 7, 2010 9:54:12 AM

Shop Packet Print

Page 3

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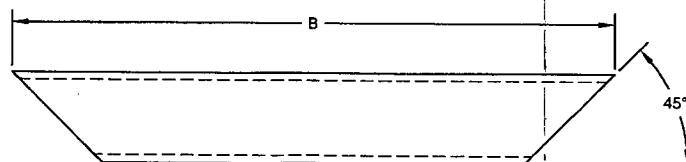
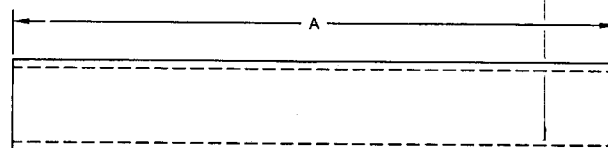
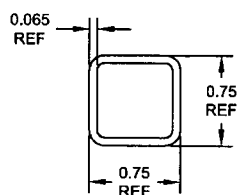
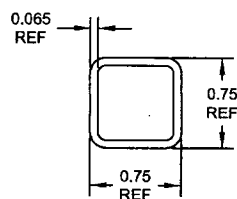
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PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39450
B810-4-07

RELEASED
08-28-21/10



NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO 'B' FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

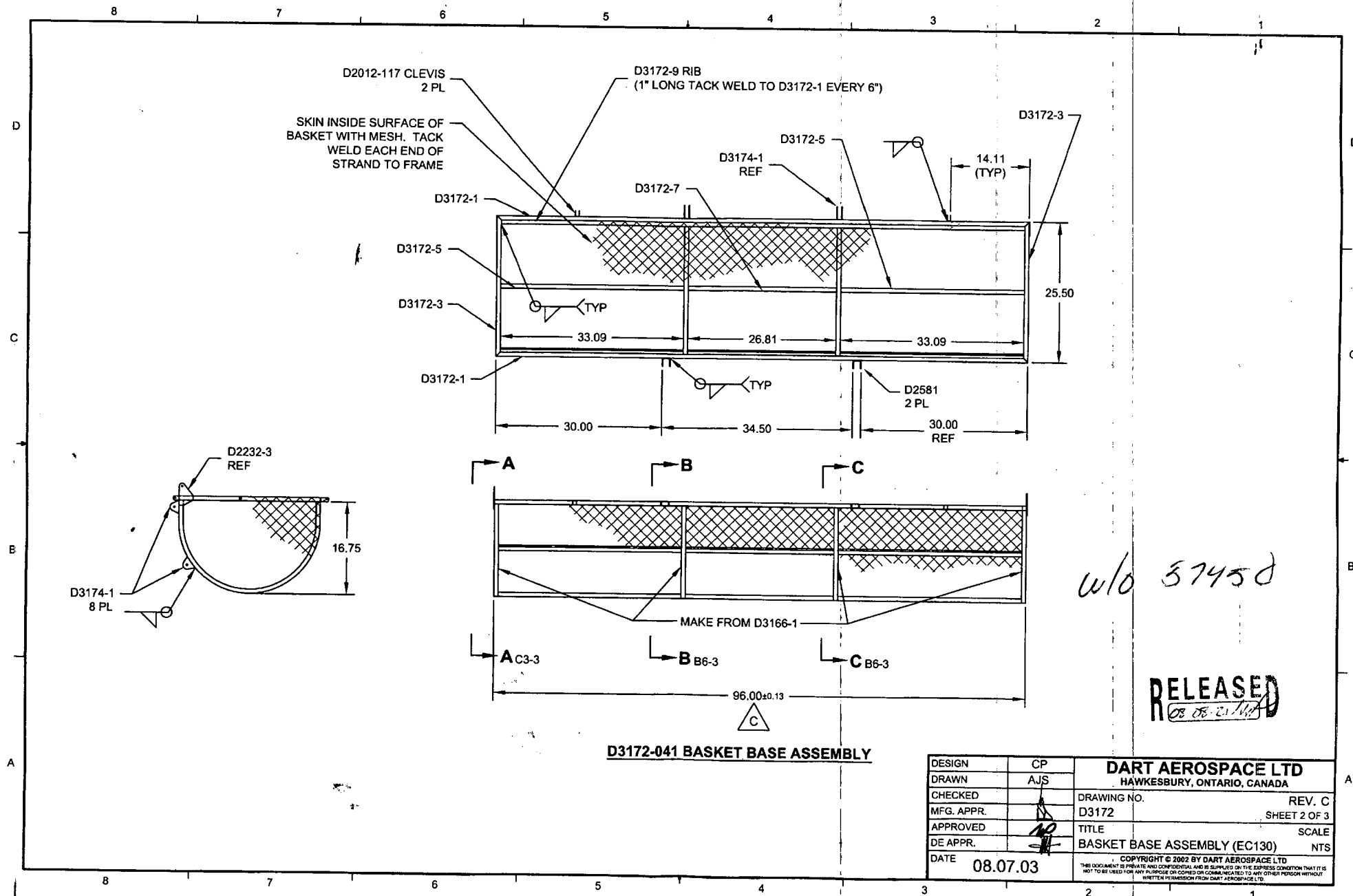
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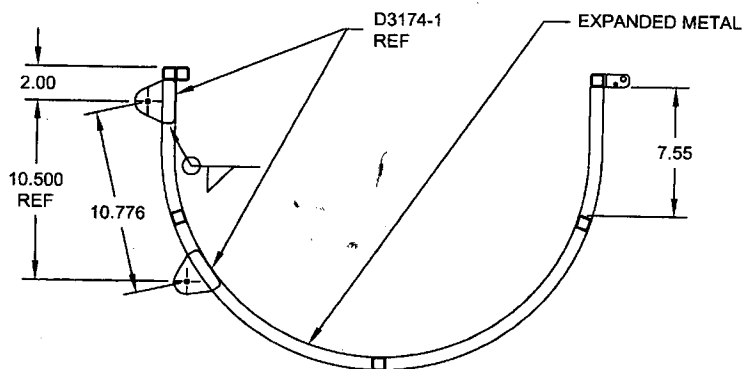
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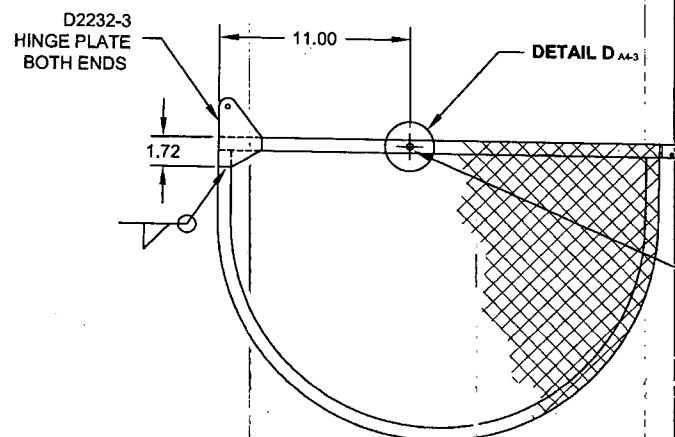
8 7 6 5 4 3 2 1

D
C
B
A

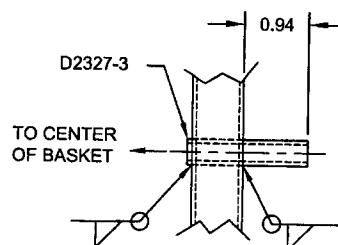
D
C
B
A



SECTION B-B_{B5-2}
AND SECTION C-C_{B3-2}
RIB DETAIL
SCALE 2X



SECTION A-A_{B5-2}
SPACER DETAIL
SCALE 2X



DETAIL D_{D3-3}
SCALE 4X

w/o 57450

RELEASED
08-08-21

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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